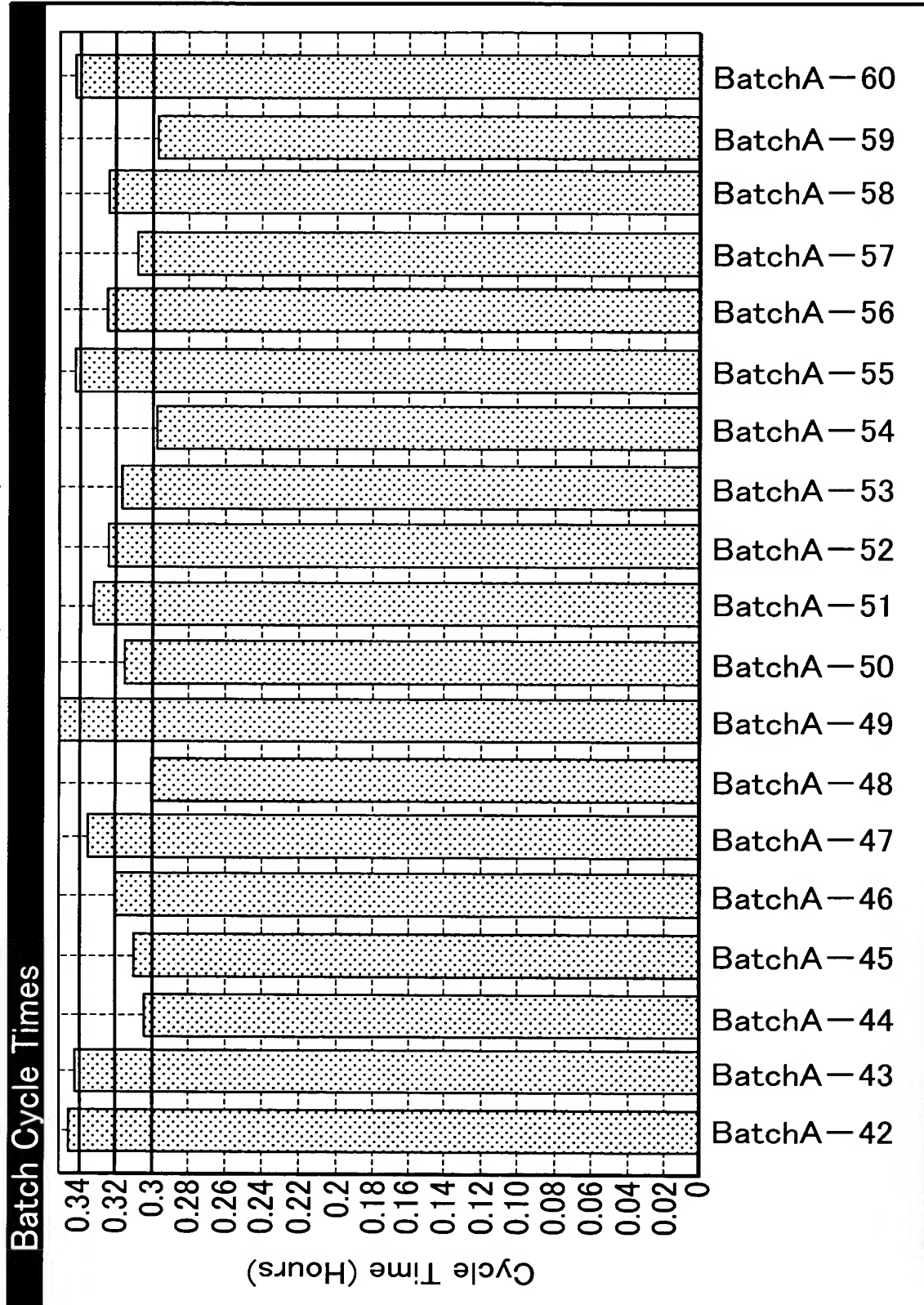
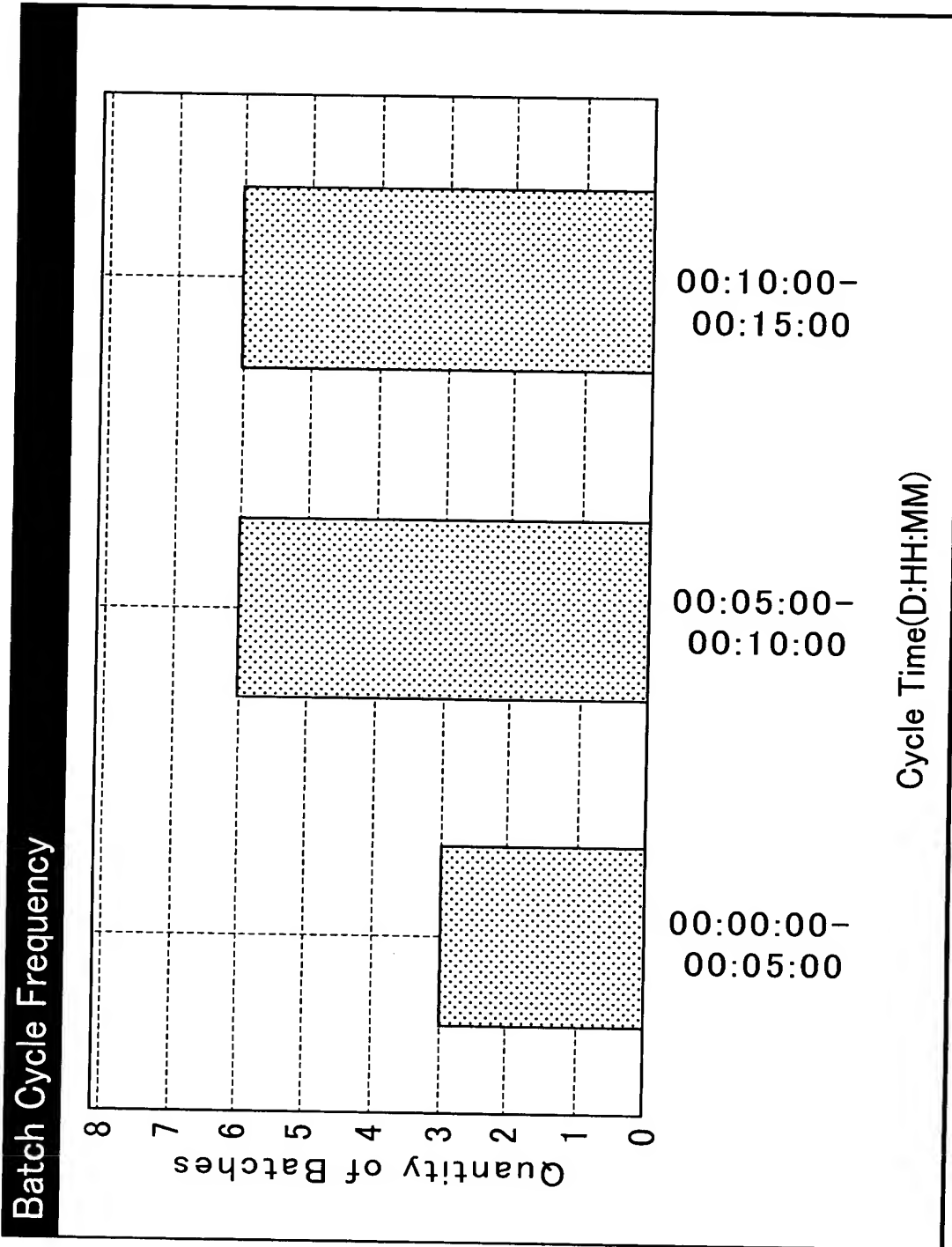


FIG.1 (Prior Art)



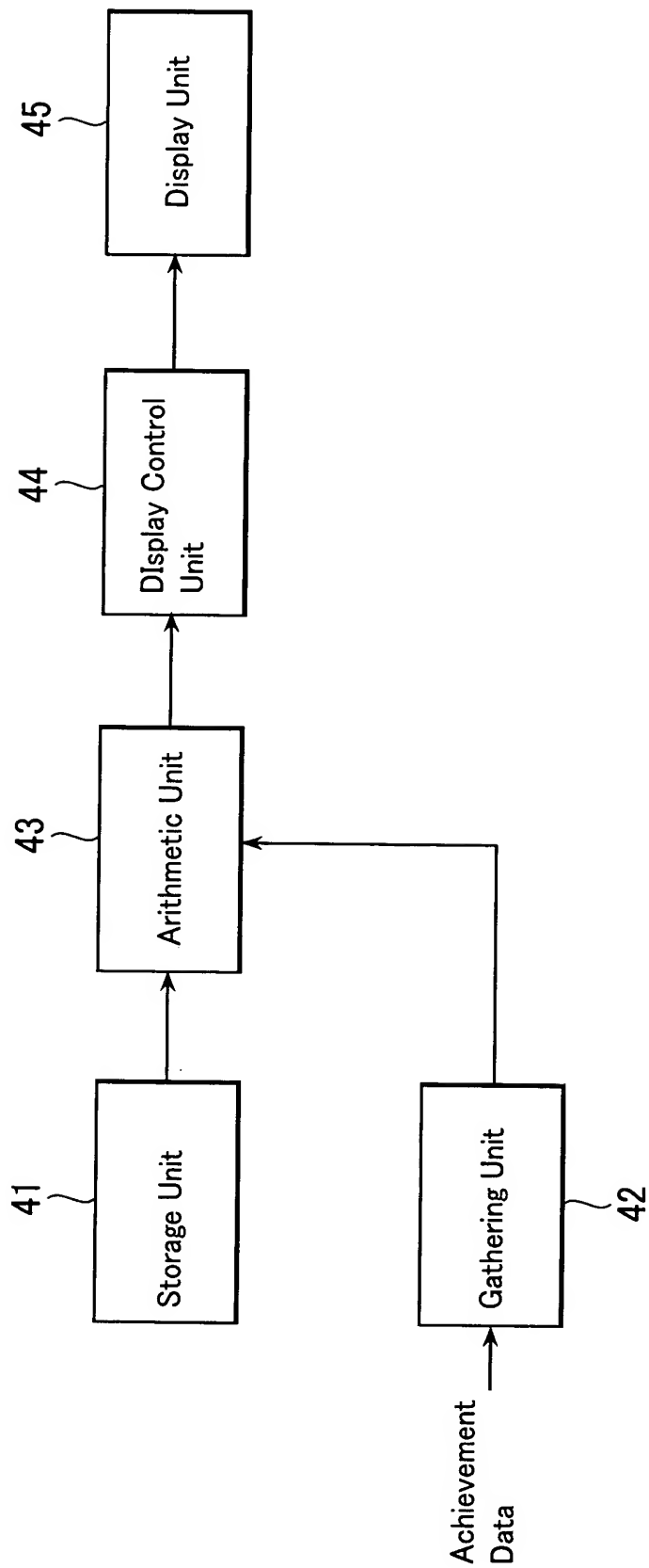
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FIG.2 (Prior Art)



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FIG.3



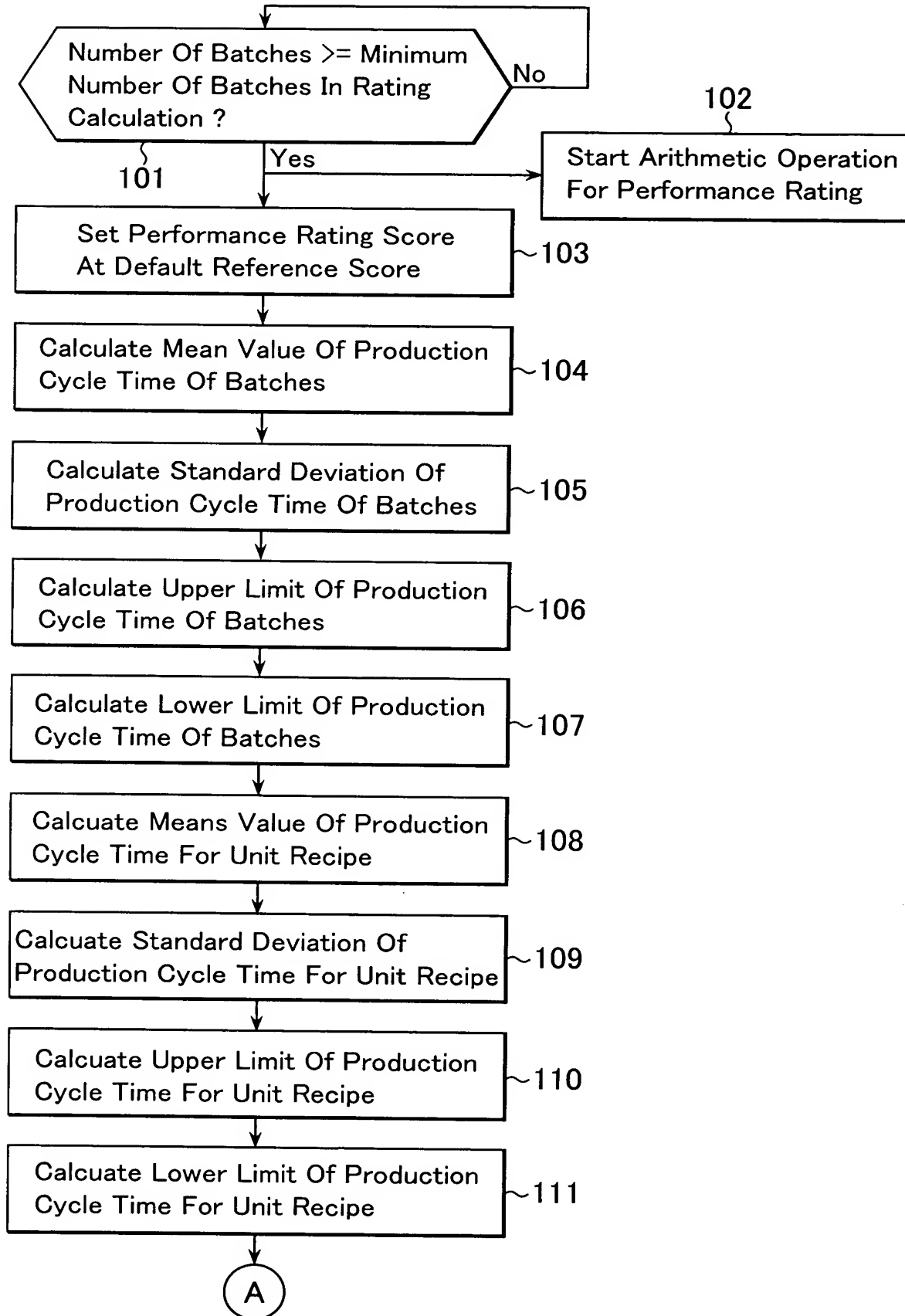
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FIG.4

Performance Rating Items	Rating Values (Default Values)
Performance Rating (Default Reference score)	70
Subtraction Due To Abort	25
Minimum Number Of Batches In Rating Calculation (Same recipe)	5
Subtraction In Case Batch Production Cycle Time Exceeds Standard Upper Deviation Limit	20
Subtraction In Case Batch Unit Recipe Production Cycle Time Exceeds Upper Standard Deviation Limit	10
Addition In Case Batch Production Cycle Time Is Within Mean Value And Upper Standard Deviation Limit	10
Addition In Case Batch Production Cycle Time Is Within Mean Value And Lower Standard Deviation Limit	15
Subtraction In Case Batch Production Cycle Time Exceeds Lower Standard Deviation Limit	20
Subtraction In Occurrence Of Hold	10
Time In Hold Limit (%)	0
Subtraction In Case Time In Hold Limit Is Exceeded	15
Number Of Alarms Limit	0
Subtraction In Case Number Of Alarms Limit Is EXceeded	15
Number Of Alarms Limit Of Unit Recipe	0

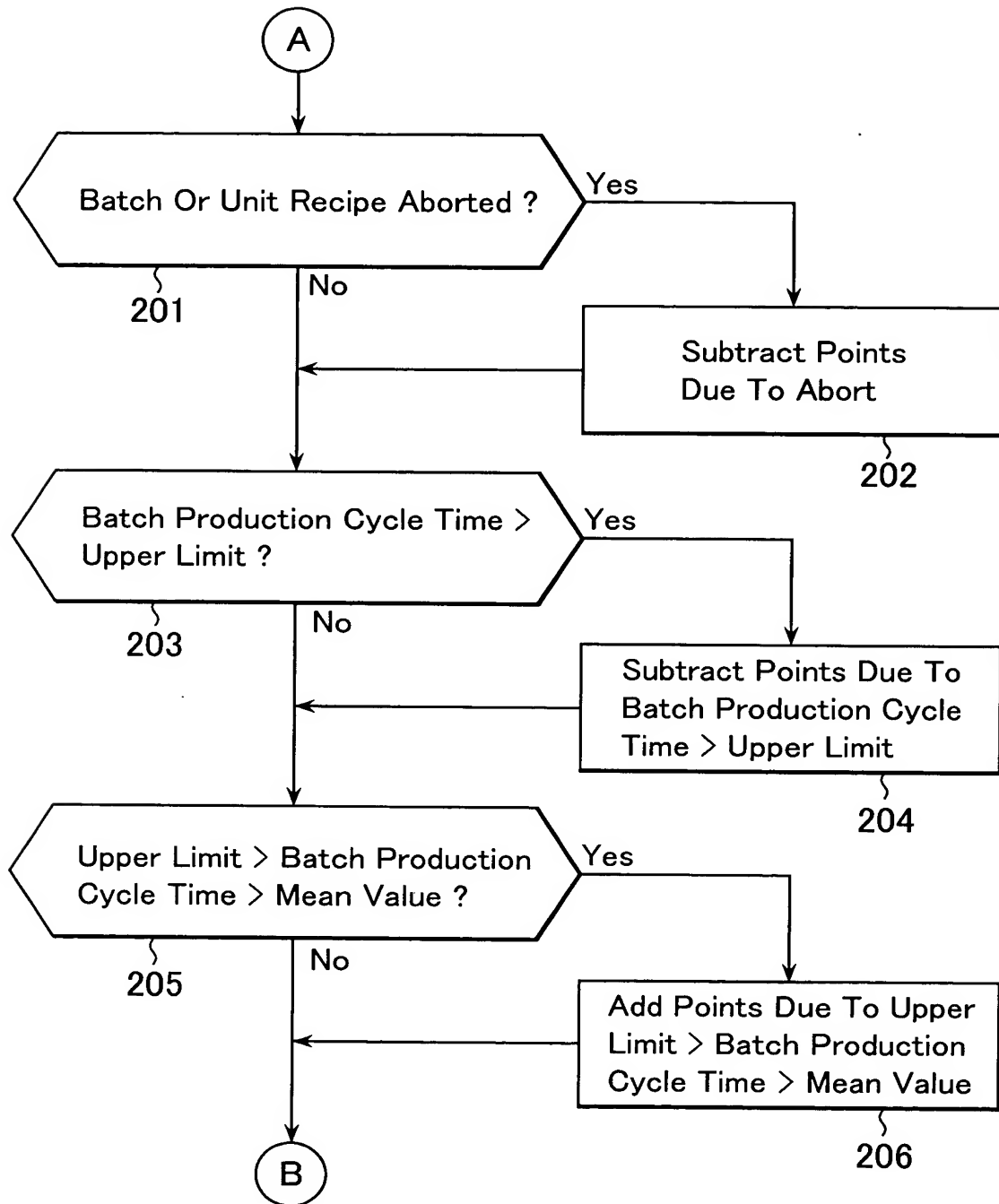
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FIG.5



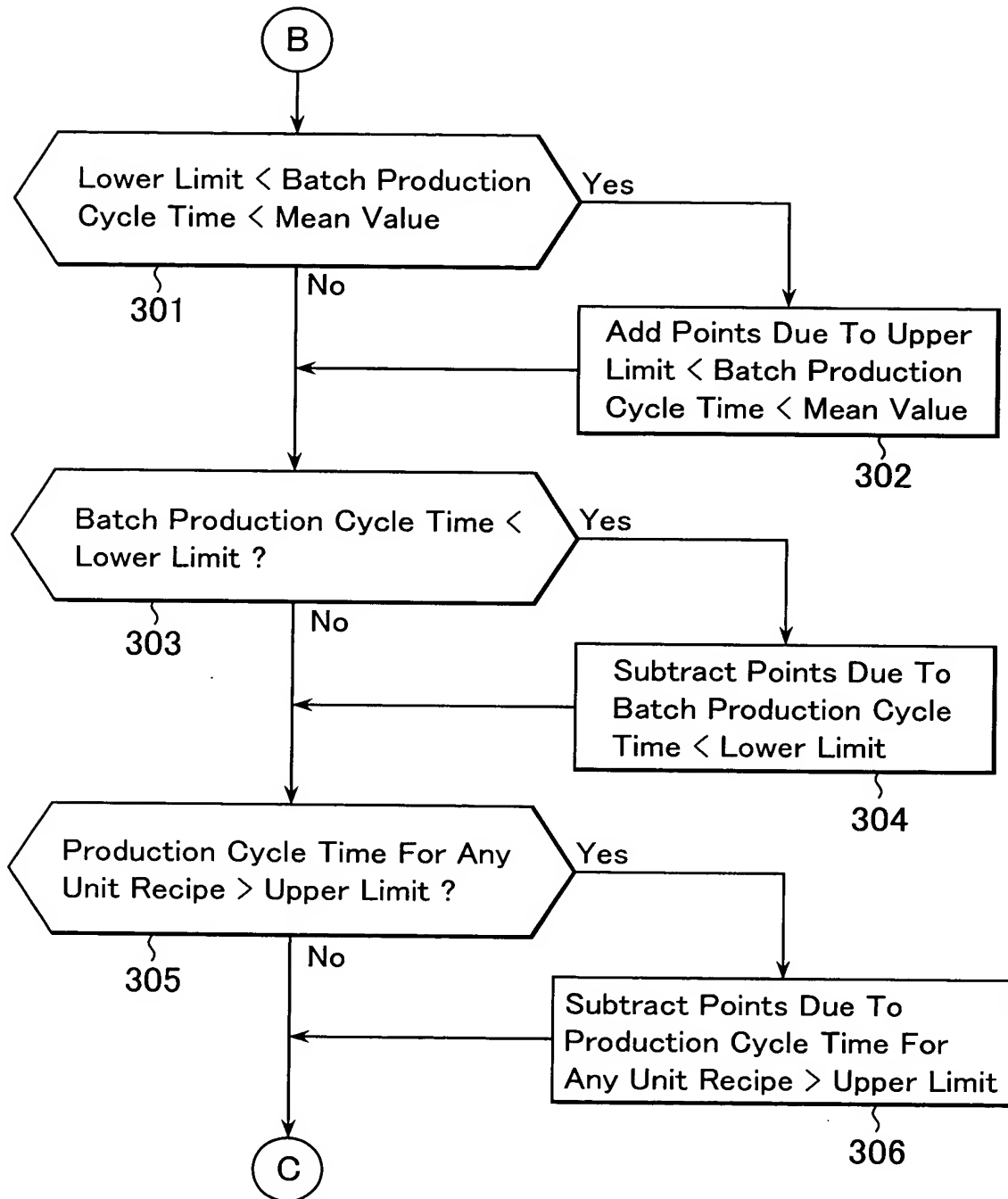
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FIG.6



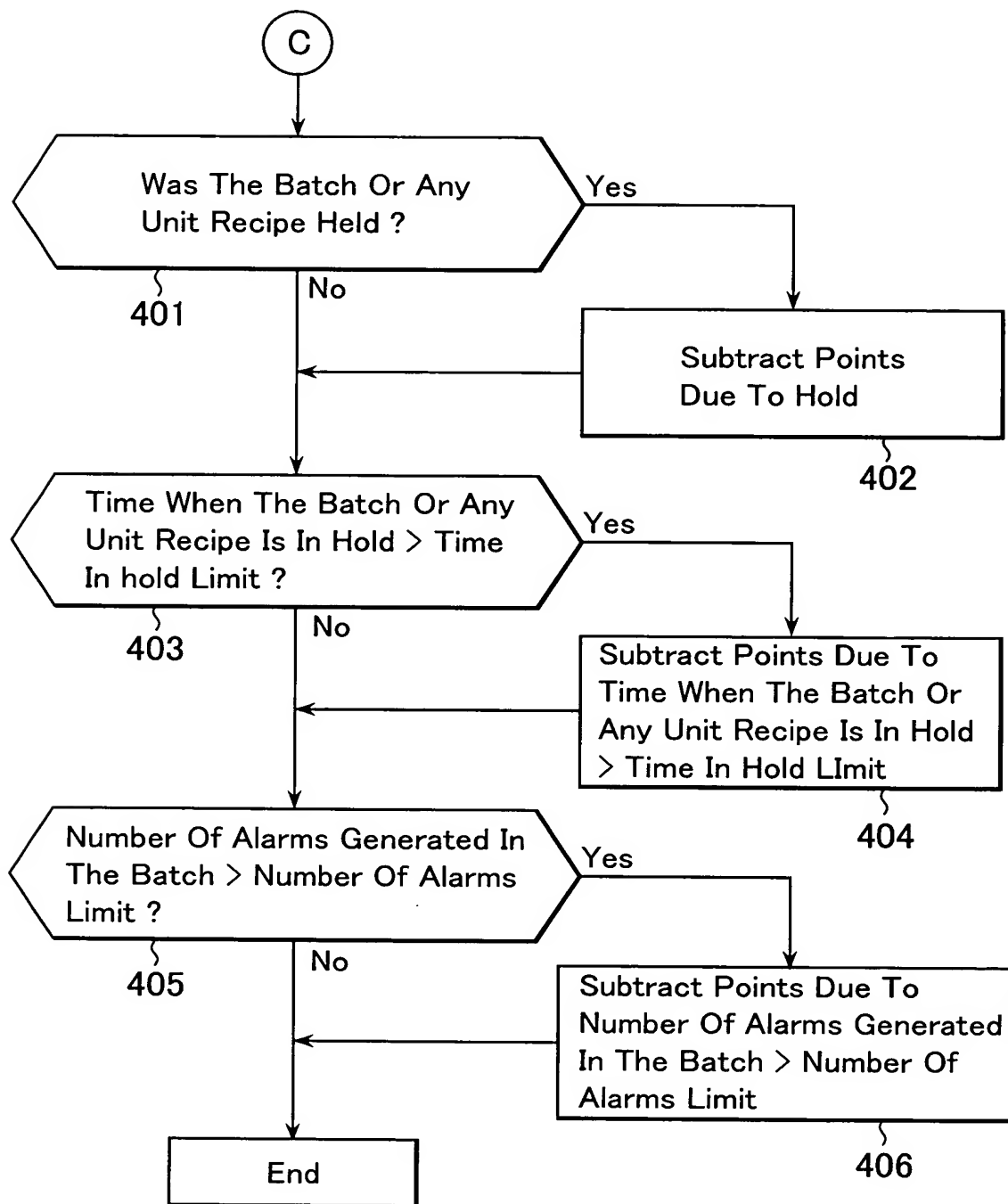
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FIG.7



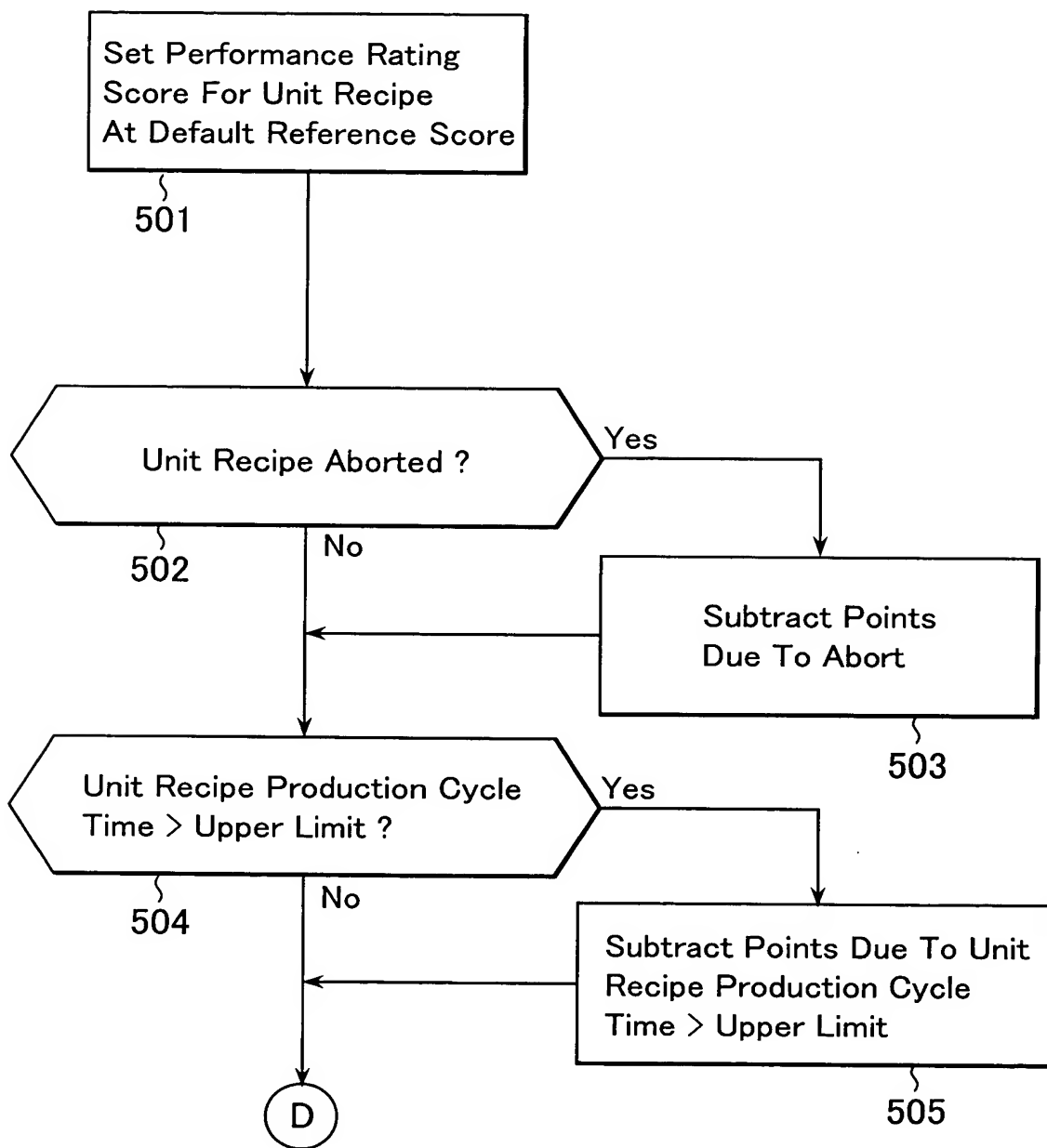
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FIG.8



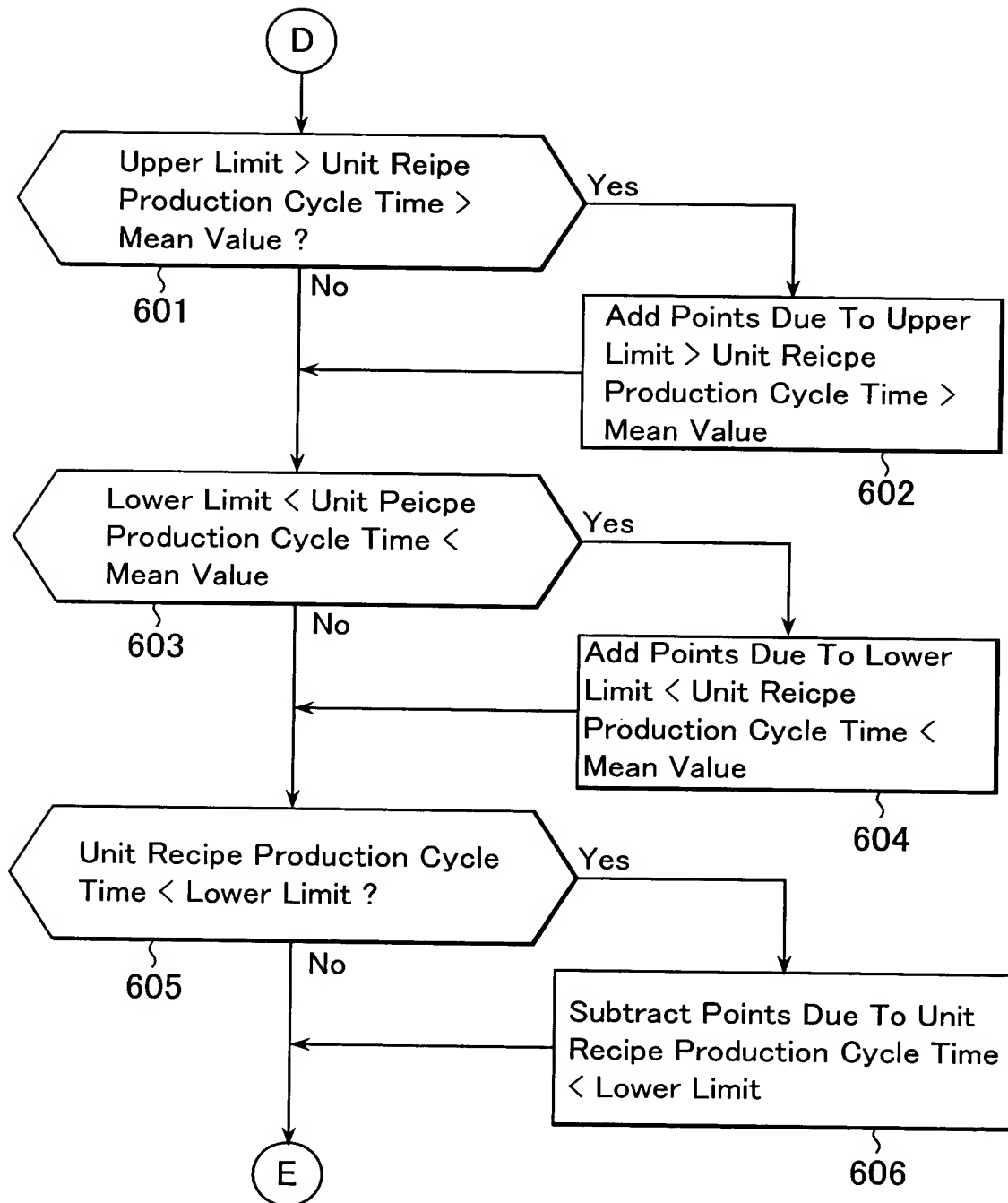
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FIG.9



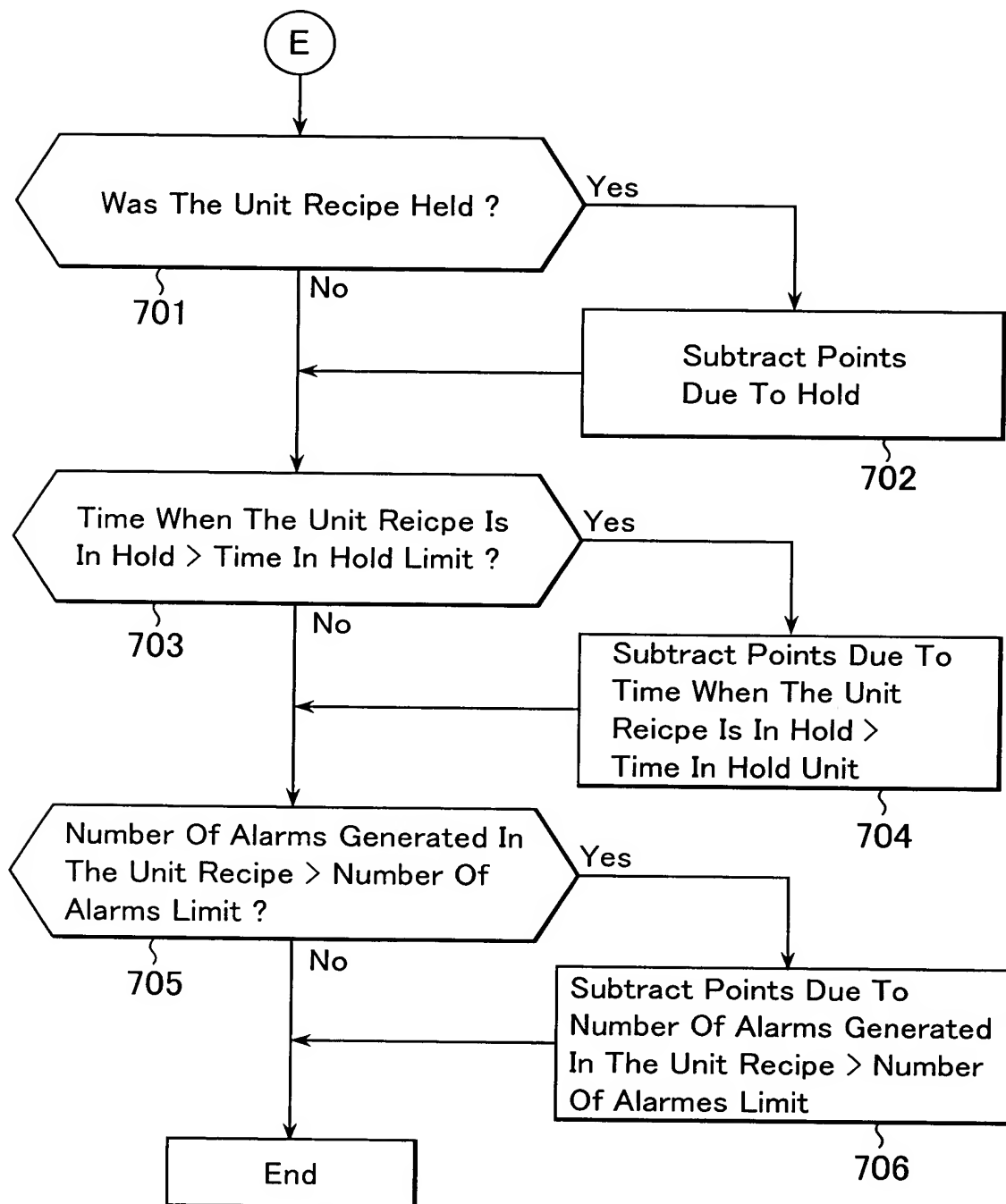
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FIG.10



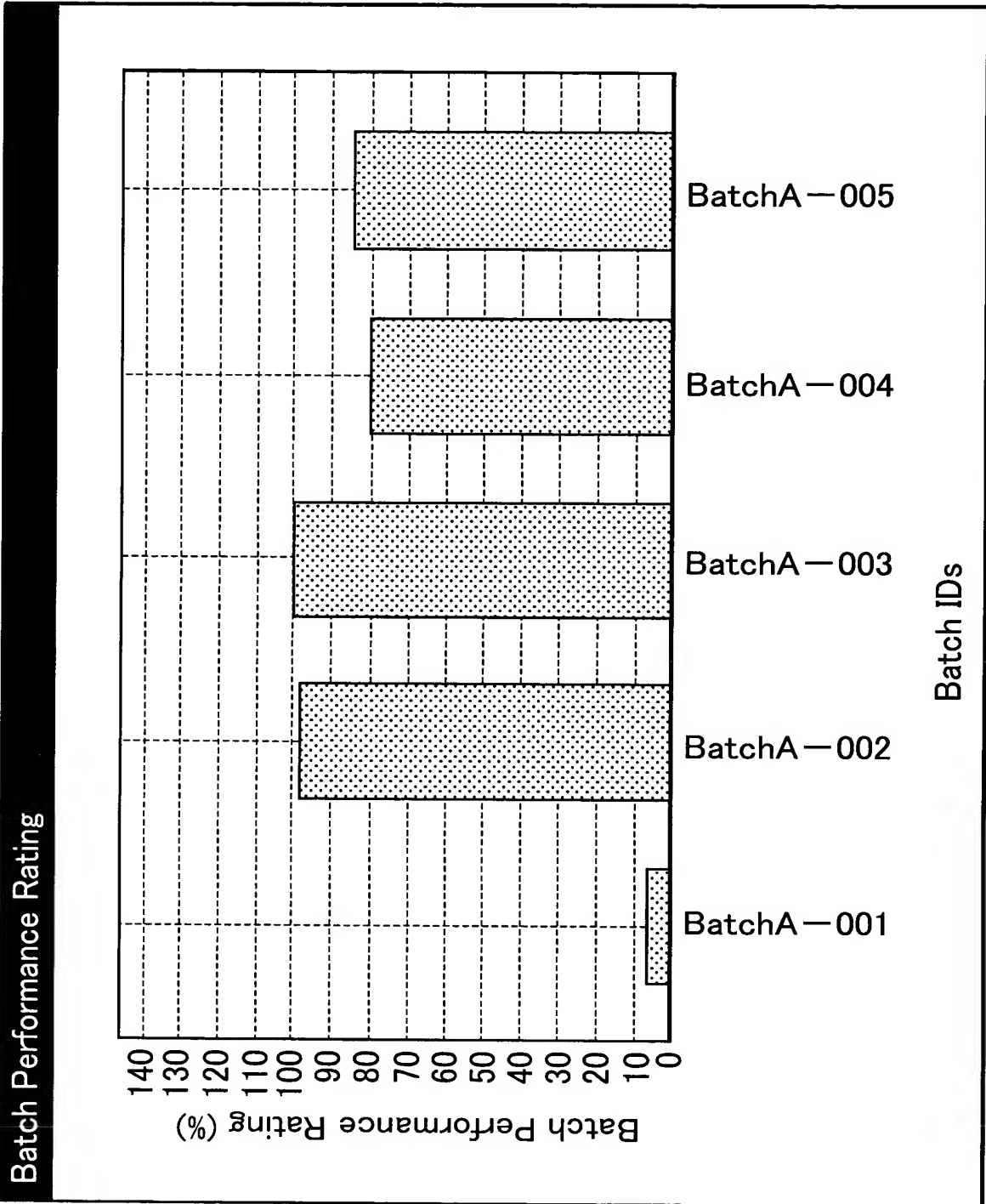
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FIG.11



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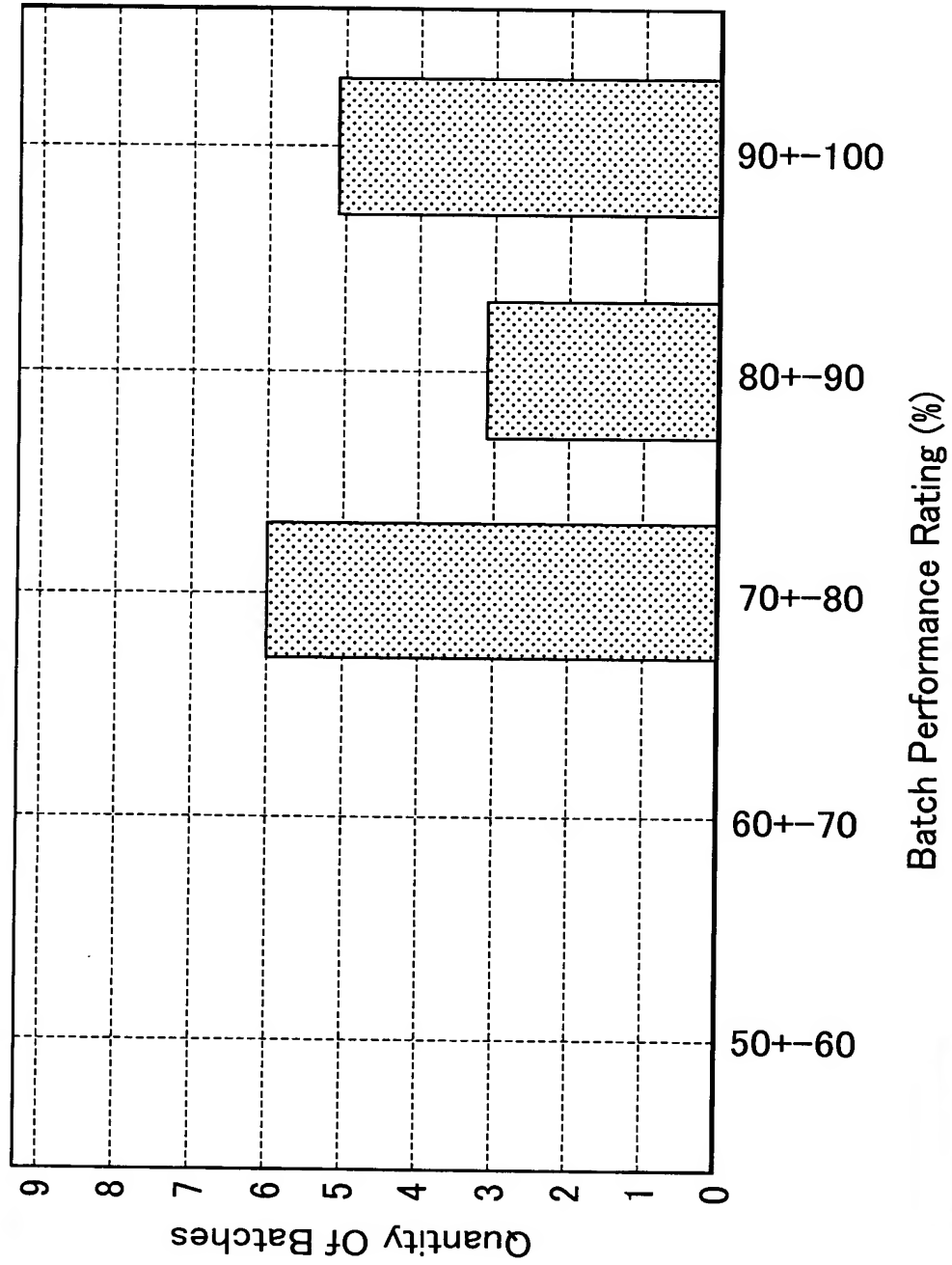
FIG.12



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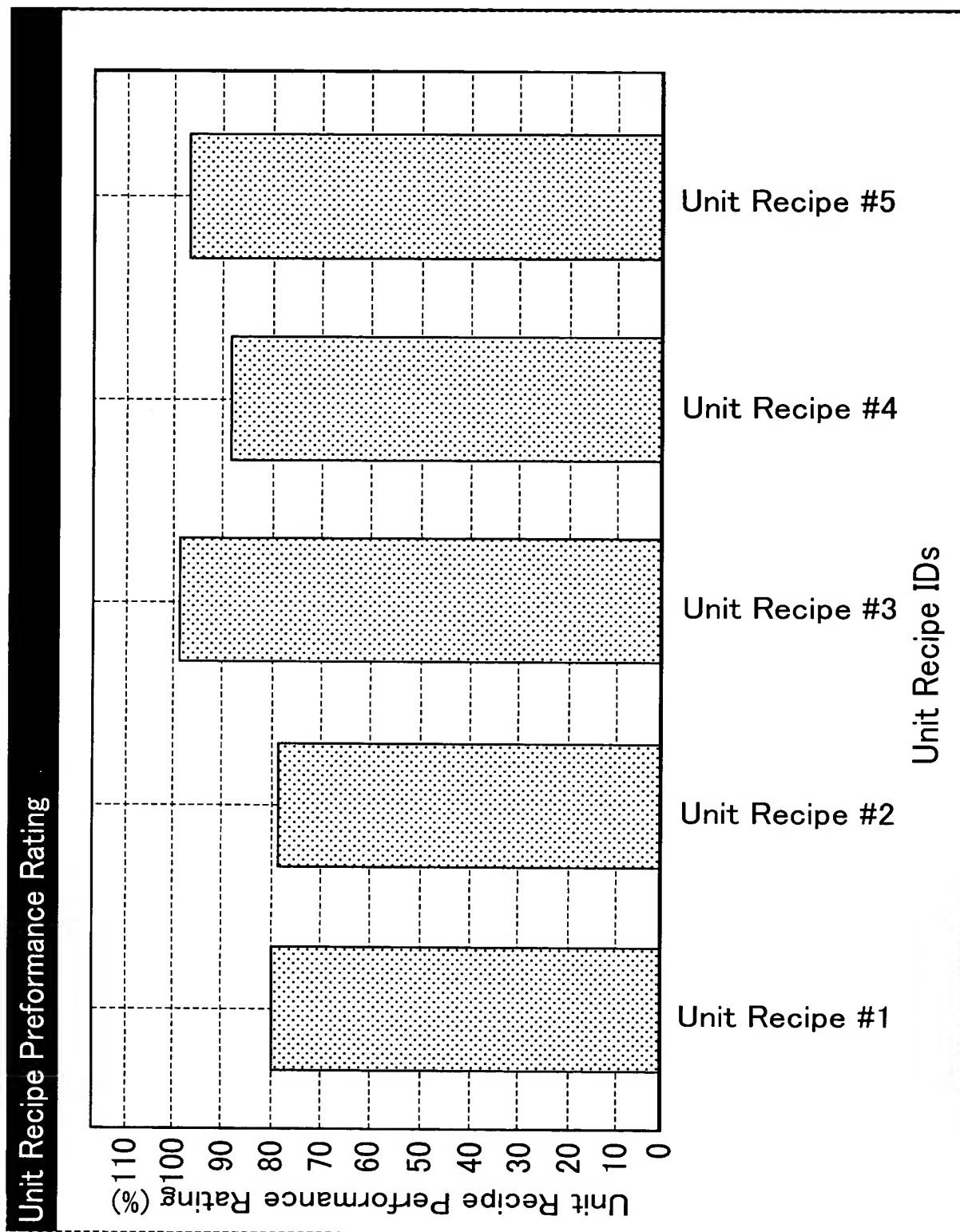
FIG.13

Batch Performance Rating Frequency



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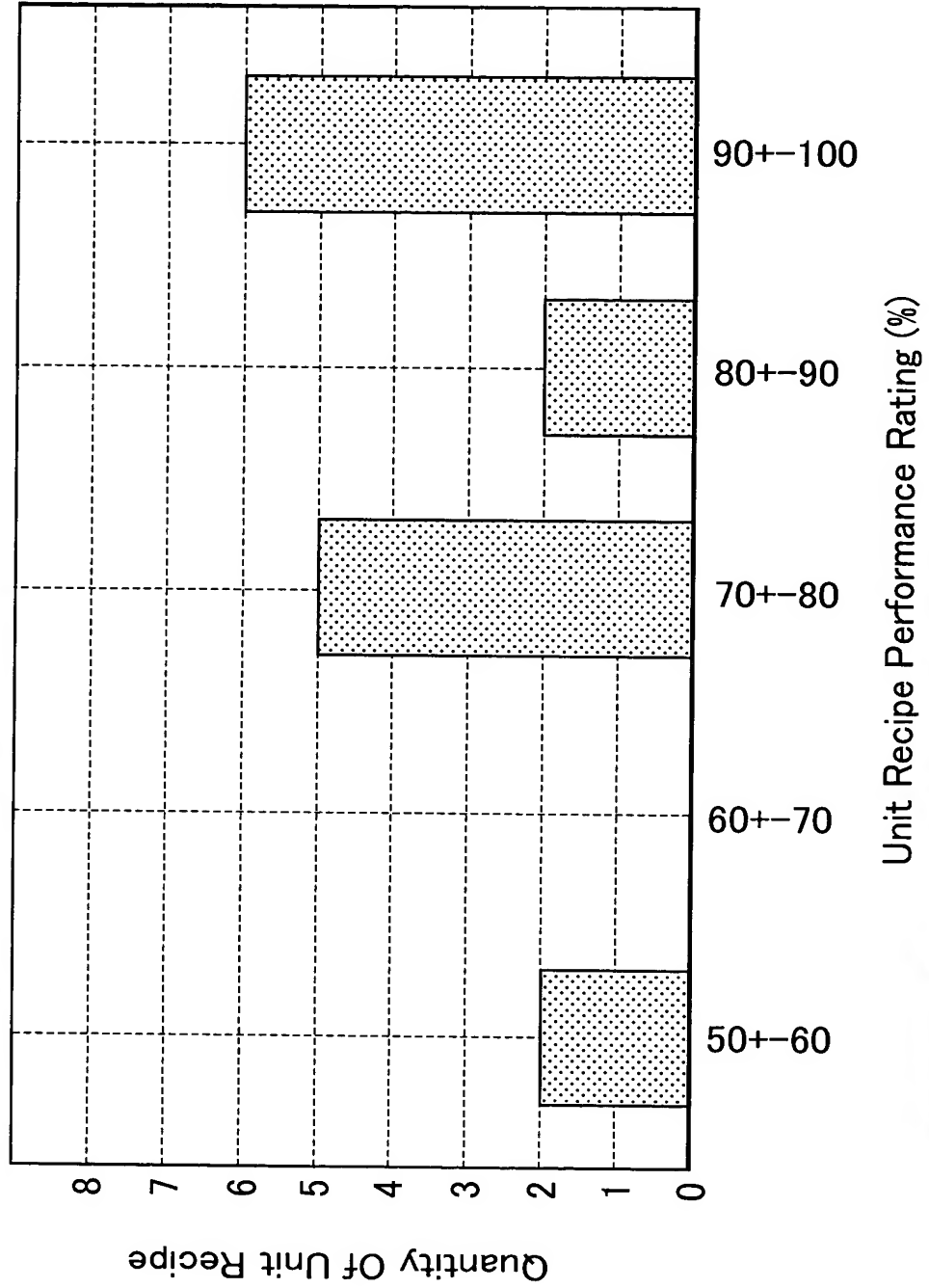
FIG.14



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FIG.15

Unit Recipe Performance Rating Frequency



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FIG.16

